

Work Order ID 134160

134160

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Friday, July 03, 2015 3:46:36 PM

Item ID: D3180-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly, LH
 Start Date: 7/03/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/03/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLS Date: JUL 06 2015 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3180	C								

100 0.00
 100 NC BRAKE 2 FF JUL 06 2015
 Brake NC Memo 0.01
 Brake NC 1-Punch Tubing to length as per Dwg D3180-1 using DT8313, DWG D2638

110 0.00
 110 Small Fab 2 FF JUL 06 2015
 Small Fab Memo 0.00
 Small Fab 1-Drill holes as per Dwg D3180
 2-Bend strut as per Dwg D3180
 3-Deburr edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



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Work Order ID 134160

Friday, July 03, 2015 3:46:36 PM

134160

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Item ID: D3180-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly, LH
Start Date: 7/03/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/03/15 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: SC Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Small Fab					2	FF		JUL 14 2015
Small Fab	Memo	0.01							
Small Fab	1-Assemble as per Dwg D3180								
160		0.00							
160	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00				2	15-07-20		DAS 9 9-89
Quality Control									
170		0.00							
170	Identify as per dwg & Stock Location: <u>S1369</u>								
Packaging	Memo	0.00							
Packaging									

P.T.O.

DQA:

Date: 15/07/2015



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/07/2015

Work Order update only ☐

Work Order: 134160		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. 03/80-041		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. 15-5229		Scrap ☐		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☒		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: 15-07-20	Step #: 110	QTY Effective: 2				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
Dimension 24.6" is 20.22" and Dimension 9.6" is 12". Dimension 41.8" is good. 15-07-20 R.C. tooling not to drawing. operator not checking drawing.				ACCEPTABLE DEVIATION THIS W/O. OPERATOR TO REVIEW TOOLING AND MANUFACTURE PART TO DWG.			
				Completed By Lead hand / Supervisor Approval Verification DAS 30 9-89 JUL 20 2015			
				QC / QA Coordinator Approval DAS 9 9-89 15-07-20			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	☒ Outside Dimensions		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☒	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

Work Order ID 134160***134160***

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Item ID: D3180-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly, LH
Start Date: 7/03/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/03/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

SH 15/7/21
MCS JUL 2 1 2015
MCS JUL 2 1 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

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Work Order ID: 134160

134160

Parent Item: D3180-041

D3180-041

Parent Item Name: Strut Assembly, LH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A03.01.27New issueKJ/RF
IPP Rev:B 07-06-28 Asper Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
A1449		Purchased					Each	1,067.000		2			
A1449									**		FF	JUL 06 2015	
Grommet													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST548			1067					
					1487			1067		2			
D2022-101		Manufactured					Each	194.0000		4			
D2022-101									**		FF	JUL 06 2015	
Spacer													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST002			93					
					107903			80					
					129976			13		4			
					ST012a			101					
					132703			101					
D2690-6		Manufactured					Each	32.0000		2			
D2690-6									**		FF	JUL 06 2015	
Lanyard													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST009			32					
					132746			20					
					133506			2		2			
					134004			10					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER : _____																					

Picklist Print

Page 2

Friday, July 03, 2015 3:46:36 PM

Work Order ID: 134160

134160

Parent Item: D3180-041

D3180-041

Parent Item Name: Strut Assembly, LH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

M304TR0.750W.065

Purchased

No

f

174.0000

7.543789

M304TR0 750W 065******

FF JUL 06 2015

304 RD Tube .750 x .065W

LocationLoc QtyLoc Code

GA002

174

114002

10

118390

2

m129493

162

Each

1.0000

2

FF JUL 14 2015

MS17984-C310

Purchased

No

MS17984-C310

Quick Release Pin

LocationLoc QtyLoc Code

ST315

1

m130953

1

Each

1,618.000

2

FF JUL 06 2015

MS21042L3

Purchased

No

MS21042L3

Nut

LocationLoc QtyLoc Code

FP001

393

M130922

393

GA

440

M131317

440

ST305

785

116549

12

126333

49

M128754

2

M132123

17

M132382

705

Friday, July 03, 2015 3:46:36 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
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OTHER : _____																					

Picklist Print

Friday, July 03, 2015 3:46:36 PM

Work Order ID: 134160

134160

Parent Item: D3180-041

D3180-041

Parent Item Name: Strut Assembly, LH

Start Date: 7/03/15

Required Date: 7/03/15

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-10

Purchased

No

Each

489.0000

2

MS27039-1-10

**

FF

JUL 06 2015

SCREW

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

238

m129541

238

2

ST285

210

m123522

2

m130358

8

m132640

200

NAS1149D0363J

Purchased

No

Each

1,303.000

6

NAS1149D0363.J

**

FF

JUL 06 2015

Washer

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

134

m128429

134

ST269

600

2799

4

6140

8

m126319

7

m131618

17

m132317

564

6

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

Work Order update only ☐

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